

Date: Wednesday, 9/26/2007 2:08:56 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 34893		
Estimate Number	: 10725		
P.O. Number	: <i>NA</i>	Part Number	: D2652
This Issue	: 9/26/2007	S.O. No.	: <i>NA</i>
Prsht Rev.	: NC	Drawing Number	: D2652 REV A
First Issue	: <i>NA</i>	Project Number	: N/A
Previous Run	: 34593	Drawing Revision	: A
		Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/12/2007
Checked & Approved By	: <i>[Signature]</i> 07.09.26	Qty:	<i>350</i> Um: Each
Comment	: Est Rev: 02.06.13 Now machined in house. NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0500	303 Round Bar 0.500"
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Comment: Qty.: 0.0578 f(s)/Unit Total: 11.5500 f(s)

Material: 303 ss .500" Round Bar

(M303R0500)

Batch: *m105 839 RD 07/10/08*

TURN OVER

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

[Signature] 07/10/09 (350)

RD 07/10/08

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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[Signature] 07/10/09 (350)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RD 07/10/08

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 07/10/10

(350)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

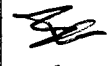
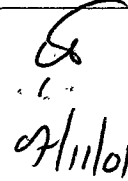
Location: _____

7/10/10 SP

350 X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ID Date: 07/11/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/08	1.0	Used 304 SS where should be 303 SS x 30 pcs, RQ	per QSS 042 07.11.01	IT ACCEPTABLE TO USE H335 304/215 FOR THIS PART ONLY.	per 07.11.01 per QSS 042	 07.11.01	per 07.11.01 per QSS 042	 07/11/01

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 34893

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 8/11/02

Job Completion



Le 8/10/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

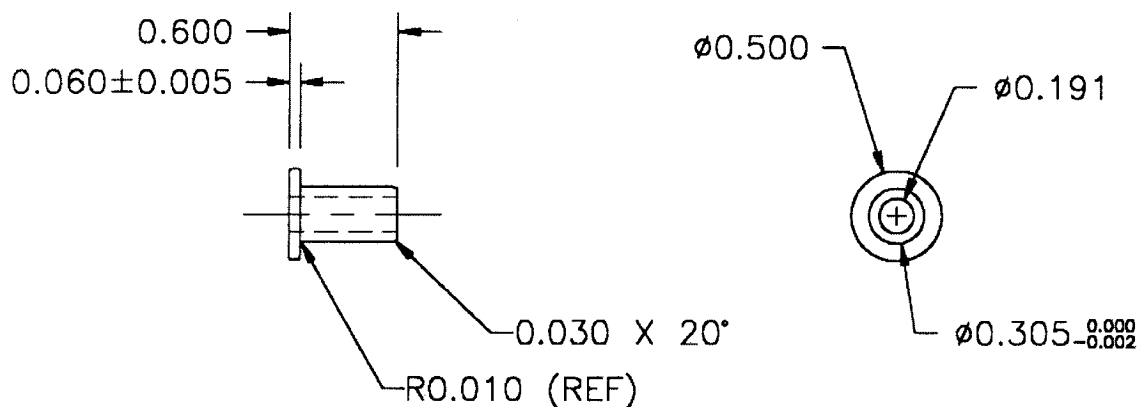
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

34893

Marc Bellavance

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 1, 2007 1:09 PM
To: 'Marc Bellavance'
Cc: 'Peter Hum'
Subject: RE: D206-642 -> D2652 Bushing

I don't have a problem making the parts out of 304/316.
It was my understanding that 303 turned better on the lathe, so we wanted to restrict the round bar to AISI 303.
Peter can sign off the deviation.

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Thursday, November 01, 2007 10:55 AM
To: 'David Shepherd'
Subject: D206-642 -> D2652 Bushing
Importance: High

David,

The following was brought to my attention:
The last batch of D2652 Bushing was machined out of 304 SS instead of 303 SS...
M-Drawing M303R Rev. A indicates that AISI 304/316 are not acceptable.
Quantity manufactured = 30.

Do you want MFG to scrap the parts, or can I (or Peter) sign off this deviation?

Marc

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.503 / Virus Database: 269.15.17/1103 - Release Date: 11/1/2007 6:01 AM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.503 / Virus Database: 269.15.17/1103 - Release Date: 11/1/2007 6:01 AM

01/11/2007